

# Work Order ID 50036

July 6, 2009 9:48:48 AM



Page 1

Item ID: D2252-11

Accept



Setup Start



Revision ID: G

Item Name: Frame

Stop



Start Date: 7/06/09 Start Qty: 2.00



Cust Item ID:

Required Date: 7/10/09 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2252

G

100

0.00



Large Fab

Memo

0.00

Large Fab

1- Cut as per dwg D2252  
2- Deburr and remove identification markings on tube

SAD 09-07-14 (2)<sup>Qty</sup>

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ 8 07/07/14 (12) F

120

Identify as per dwg & Stock Location: WA

0.00



Packaging

Memo

0.00

Packaging

SAD 09-07-15 (12)

# Work Order ID 50036

July 6, 2009 9:48:48 AM



Page 2

Item ID: D2252-11

Accept



Setup Start



Revision ID: G

Stop



Item Name: Frame

Start Date: 7/06/09

Start Qty: 2.00



Cust Item ID:

Required Date: 7/10/09

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/07/10

MF  
09-07-15

# Picklist Print

July 6, 2009 9:48:47 AM

Page 1

Work Order ID: 50036

Parent Item: D2252-11RevG

Parent Item Name: Frame

Comments:

Start Date: 7/06/09

Required Date: 7/10/09

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	680.8900	4.3789			



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	680.89	
110969	3.29	
111148	15.96	
111331	1.96	
111432	0.44	
111885	25.14	
112051	634.1	

4.3789

1.0 Sq End Bar Scrap

SAD 09-07-14

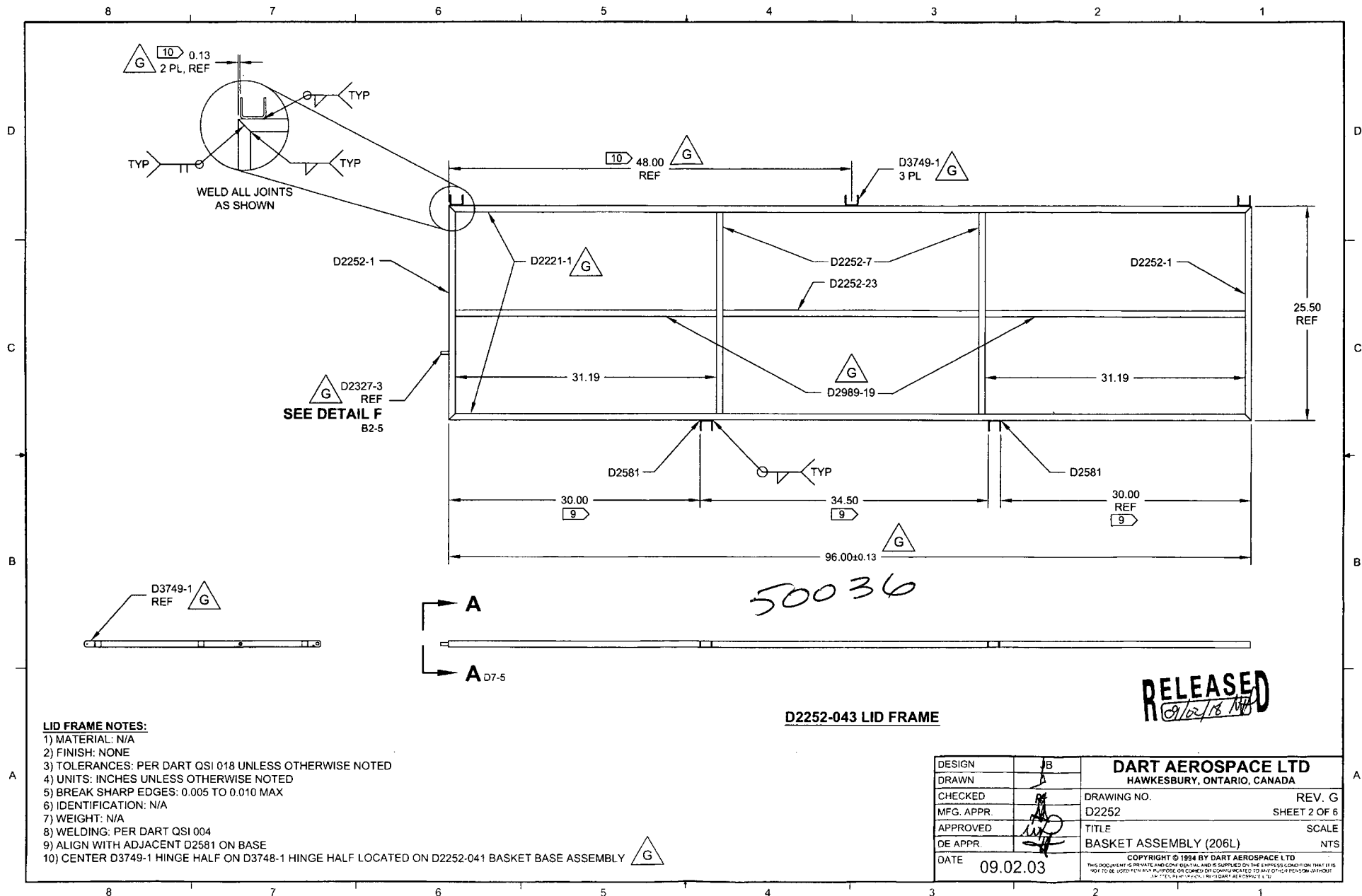
Qty  
②

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

# **NOTES:**




- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: N/A
- 9) WELDING: PER DART QSI 004

G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/-3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/-19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (2N A6-5). P/N REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/-3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH. D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	J/B	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	J		
CHECKED	AS	DRAWING NO.	REV. G
MFG. APPR.	AS	D2252	SHEET 1 OF 6
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	BASKET ASSEMBLY (206L)	NTS
DATE	09.02.03	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OTHER THAN THE ONE AUTHORIZED TO THE PERSON TO WHOM IT IS SUPPLIED.</small>	

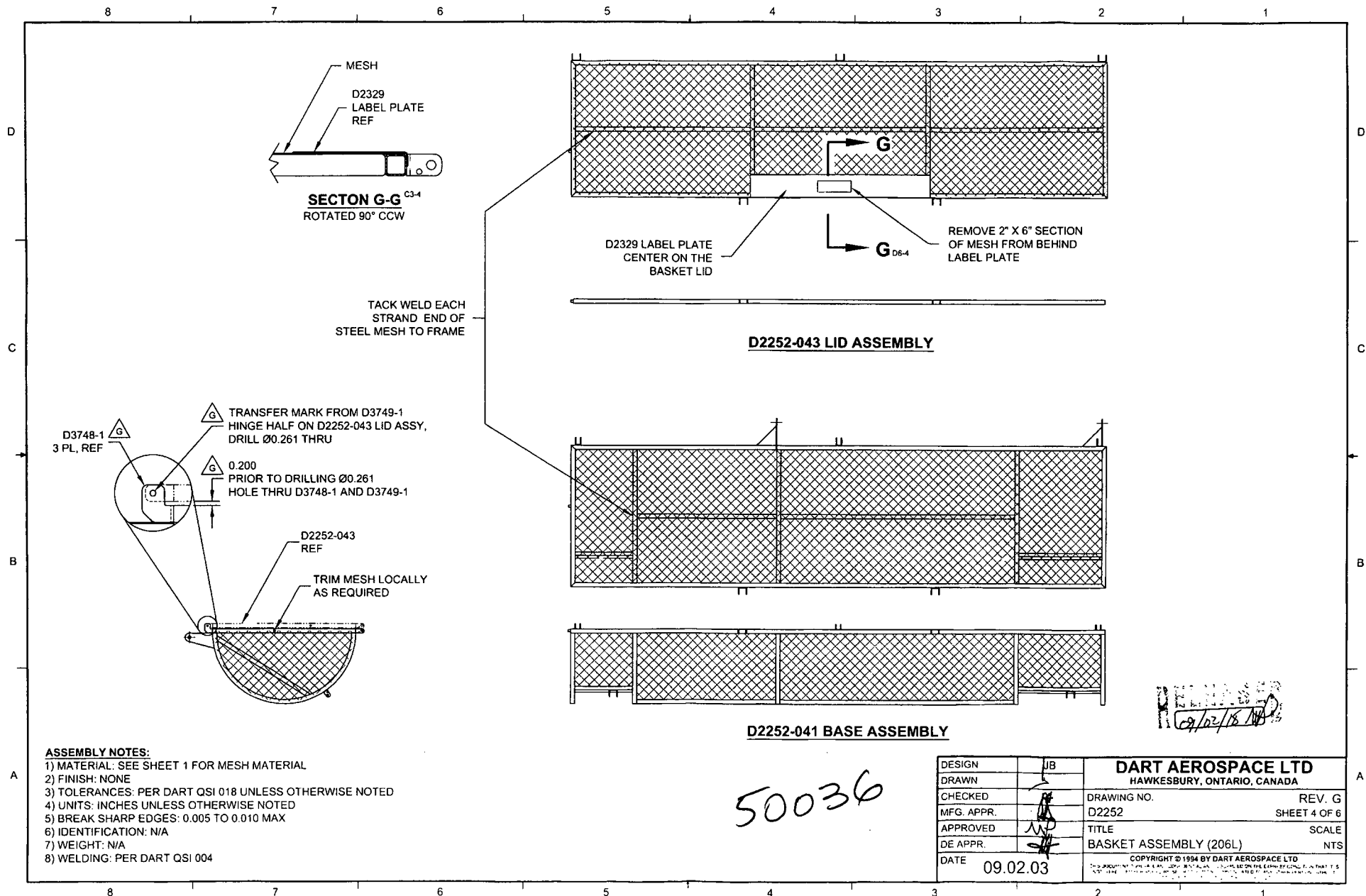


# **LID FRAME NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004
- 9) ALIGN WITH ADJACENT D2581 ON BASE
- 10) CENTER D3749-1 HINGE HALF ON D3748-1 HINGE HALF LOCATED ON D2252-041 BASKET BASE ASSEMBLY

DESIGN	JB	<b>DART AEROSPACE LTD</b>	
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MFG. APPR.		D2252	SHEET 2 OF 6
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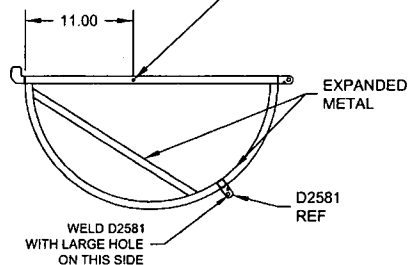




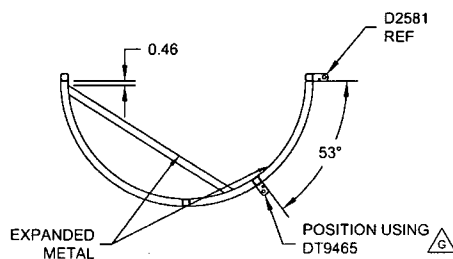


**VIEW A-A** A6-2

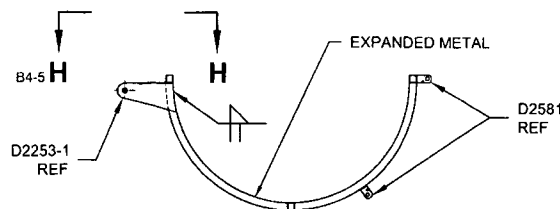
DRILL 3/8 HOLE AND  
INSTALL D2327-3  
SEE **DETAIL F** B2-5



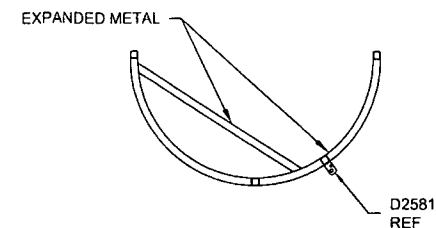
**VIEW B-B** A5-3



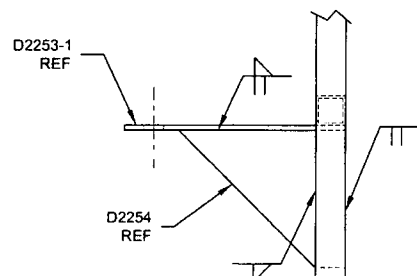
**SECTION C-C** A5-3



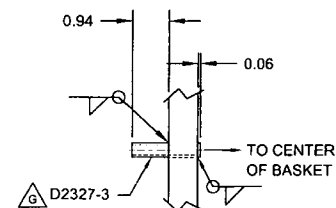
**SECTION D-D** D5-3



**SECTION E-E** A2-3



**VIEW H-H** D4-3  
D5-5



**DETAIL F** C5-3  
SPACER INSTALLATION C6-2

**RELEASED**  
59/12/16 NIP

50036

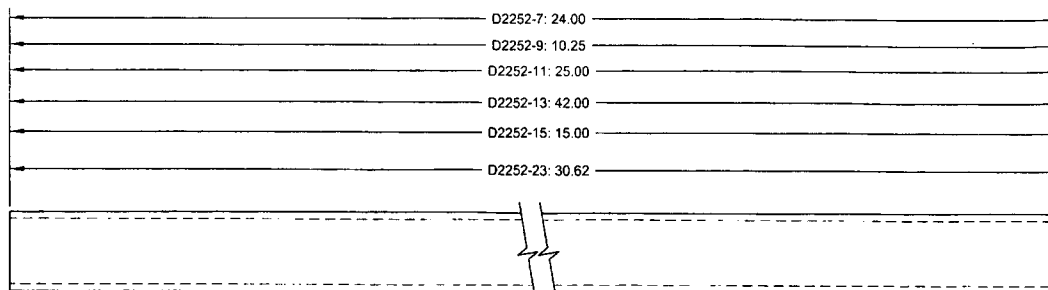
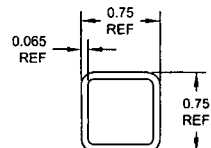
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8 7 6 5 4 3 2 1

D

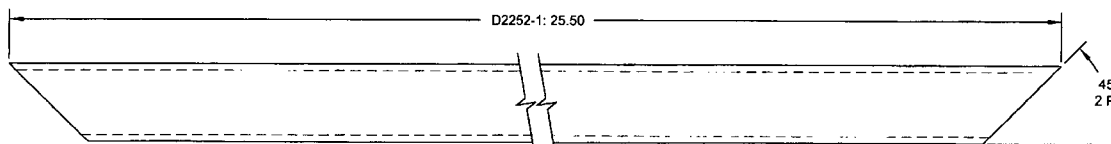
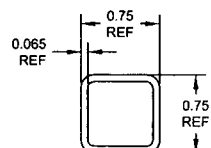
D



D2252-7 FRAME  
D2252-9 FRAME  
D2252-11 FRAME  
D2252-13 FRAME  
D2252-15 FRAME  
D2252-23 FRAME

C

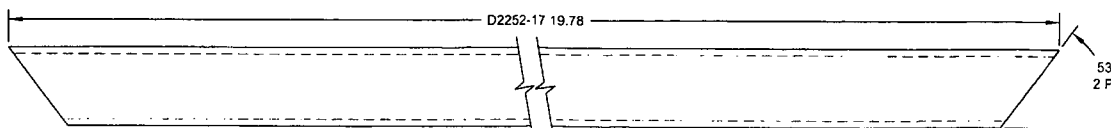
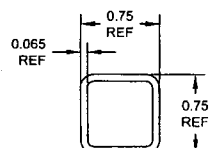
C



D2252-1 FRAME

B

B



D2252-17 FRAME

A





A

**NOTES:**

- 1) FRAME MATERIAL: SEE SHEET 1
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A

50036

**RELEASED**  
 2/10/16/1/1/1

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8 7 6 5 4 3 2 1